

Work Order ID 71377



Page 1

Thursday, June 30, 2011 10:48:32 AM

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 6/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-06-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580-041	Rev.D DEO-D1

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041

CHG004

002

N/A

110 0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

BE 11/07/05
BE 11/07/05
BE 11/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for swaging as per QSI 002								
130		0.00							
QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

B 11/07/05

11-7-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skid tubes

Skid tubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R ☐ ☐ Aluminum Rod

M15778

BE 11/07/07

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

WELDED A/R M15778
BE 11/07/07

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

BE 11/07/12

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150

0.00



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

SWA/R

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Required Date:	7/12/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00							
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00							

8/11/12

1 0 11-7-12

1X 0 M 11/07/13

7:40
320
8:10
0.00
0.00

M117746

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 24 110719

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 11175 ☐Sikaflex expire date: 15/6

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 11175 ☐Sikaflex expire date: 15/6

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 11178631 0 94 1107/19

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S w/ 6/19

(40)

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PP 71947

P 4/17/21 (1)

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u h / 21

me

11-07-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

Thursday, June 30, 2011 10:48:38 AM

Page 1

Work Order ID: 71377

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 6/30/2011

Required Date: 7/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1	D2579	Manufactured	No			140	Each	443.0000	20	20			
---------	-------	--------------	----	--	--	-----	------	----------	----	----	--	--	--



Spacer

Location	Loc Qty	Loc Code
LG002	443	
66929	106	
67129	196	
67308	1	
67430	140	

BE 4/07/07
B 70761 20

D2580-1		Manufactured	No			110	Each	7.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



205 Skidtube bent detail

Location	Loc Qty	Loc Code
LG	5	
69731	1	
70260	2	
70784	2	
ST046	2	
70785	2	

BE 11/07/05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, June 30, 2011 10:48:38 AM

Page 2

Work Order ID: 71377

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 6/30/2011

Required Date: 7/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2576-3

Manufactured No

140 Each

47.0000

1

1



Step (maching detail)

Location

Loc Qty

Loc Code

LG

47

66156

47

D2855

Manufactured No

200 Each

43.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP007

43

53791

6

65519

2

65569

35

AN3-5A

Purchased No

200 Each

1,089.000

2

2



Bolt

Location

Loc Qty

Loc Code

ST350

1089

115371

289

117423

800

AN960JD10L

NAS1149D0332J

Purchased No

200 Each

0.0000

2

2



Washer

ALS7-1032-130

Purchased No

200 Each

1,209.000

50

50



Insert

Location

Loc Qty

Loc Code

ST282

1209

117717

1209

BE 6/7/07

u 11/07/19

x1

u 11/07/19

x2

11117087 (x2) 11/07/19

u 11/07/19

x50

Thursday, June 30, 2011 10:48:39 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID: 71377

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 6/30/2011

Required Date: 7/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 2,108.000 50 50



BOLT



Handwritten: 110719

Location

Loc Qty

Loc Code

ST350

2108

117313

2

117688

776

117795

500

117872

22

118012

500

118112

308

AN960C10L NAS1149C0332 Purchased No



washer

D3566-13

Manufactured No

200 Each 0.0000 50 50



Gasket

Handwritten: 1118306



Handwritten: (x50) 110719

Location

Loc Qty

Loc Code

FP

24

69281

24

FP014

2

68341

2

D3566-5 Manufactured No



Gasket

200 Each 16.0000 1 1



Handwritten: 110719

Location

Loc Qty

Loc Code

FP015

16

68961

16

Handwritten: 21

Thursday, June 30, 2011 10:48:39 AM

Shop Packet Print

Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Replacement Skidtube

Start Date: 6/30/2011

Required Date: 7/12/2011

Start Qty: 1.00



Required Qty: 1.00

D3566-1	Manufactured	No	200	Each	8.0000	2	2
							<u>22 110719</u>

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP015	8	B70769
68924	2	
69279	6	



x2

D3564-11	Manufactured	No	200	Each	6.0000	1	1
							<u>22 110719</u>

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP019	6	
67591	6	



41

D3564-13	Manufactured	No	200	Each	16.0000	1	1
							<u>22 110719</u>

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP016	16	
69280	16	

41

D3564-9	Manufactured	No	200	Each	11.0000	1	1
							<u>22 110719</u>

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP019	11	
67590	4	
68349	1	
69943	6	

41

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Work Order ID: 71377

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Parent Item Name: Replacement Skidtube

Start Date: 6/30/2011

Required Date: 7/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5
Wearshoe

Manufactured No

200 Each

24.0000

1 1



11/07/11

Location

Loc Qty

Loc Code

FG

2

34806

2

FP019

22

70864

22

D2594-3
O-Ring, 205 Skidtube

Manufactured No

200 Each

812.0000

16



11/07/11

Location

Loc Qty

Loc Code

FP-A

812

65518

54

66952

758

D2594-1
Plug, 205 Skidtube

Manufactured No

200 Each

265.0000

16



11/07/11

Location

Loc Qty

Loc Code

FP-A

265

42807

28

67441

7

68943

230

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #**DEO ATTACHED**

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

UNCONTROLLED COPY
SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDER

NO. 71327

11-06-30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

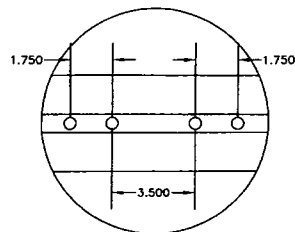
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

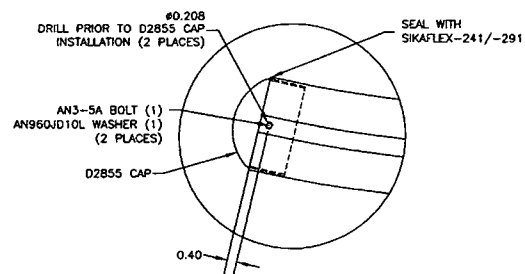
NOTE: Date & initial all entries

71377



RELEASED
07-06-28

DEO ATTACHED



D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER PERFORM

1. CHA
2. INS
3. WE
4. C'B

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

- 1. CHAMFER HOLE 0.050 X 45°**
- 2. INSERT D2579 SPACER (20 PLACES)**
- 3. WELD INTO PLACE AND GRIND FLUSH**
- 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP**

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

Diagram showing the elevation view of the bridge deck. Key dimensions and labels include:

- 37.50: Distance to aft end of D2596 web.
- 3: Triangle symbol.
- 7: Triangle symbol.
- 1.750: Dimension from centerline to the edge of the deck.
- 8.750: Dimension from centerline to the edge of the deck.
- 17.375: Dimension from centerline to the edge of the deck.
- 26.000: Dimension from centerline to the edge of the deck.
- 34.188: Dimension from centerline to the edge of the deck.
- 57.313 (REF): Dimension from centerline to the edge of the deck.
- 7 EQUAL SPACES: Label for the spacing between the deck edges.
- 8.188 PITCH: Label for the spacing between the deck edges.
- 91.500: Dimension from centerline to the edge of the deck.
- 190.0: Total width of the bridge deck.
- (D2500-1): Reference to the deck detail.
- REFER TO DETAIL A: Label for the deck detail.
- ø0.508 (TYP.) (40 PLACES): Label for the deck reinforcement.
- REFER TO DETAIL A: Label for the deck detail.

0.5 1.5 1.5 0 P D

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

REFER TO DETAIL C

D3566-1 D3566-5 D3566-13 D3564-11 D3564-5 D3564-9

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)


DESIGN	DRAWN BY

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DESIGN	<i>[Signature]</i>
CHECKED	<i>[Signature]</i>
DATE	07.02.27

DRAWN BY	PH
APPROVED	H

 DART AEROSPACE LTD. WORMSHEAD, ONTARIO, CANADA		REV
DRAWING NO.		
D2580		SHEET 2 OF 2
TITLE		SCALE
205 SKIDTURE ASSEMBLY		

1.2

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

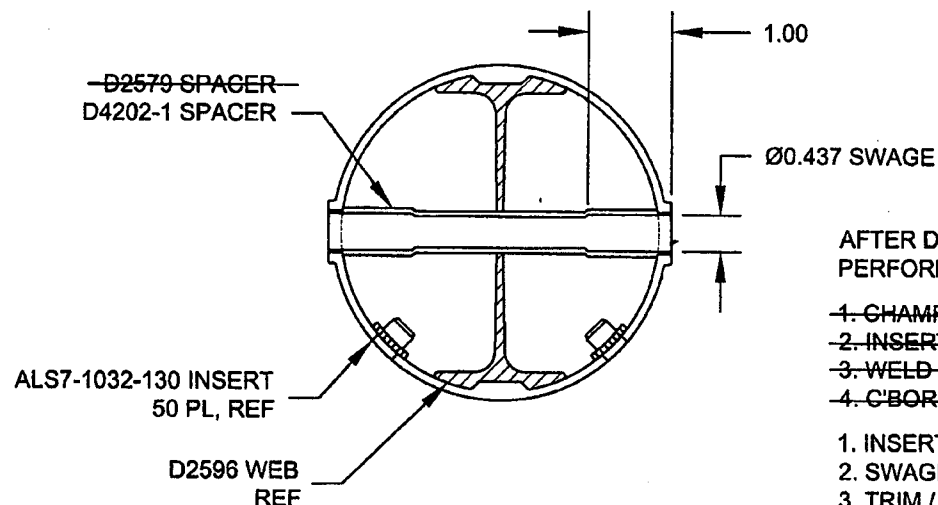
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

- ~~1. CHAMFER HOLE 0.050 X 45°~~
- ~~2. INSERT D2579 SPACER (20 PLACES)~~
- ~~3. WELD INTO PLACE AND GRIND FLUSH~~
- ~~4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP~~

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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Linda Lacelle

From: dshepherd@dartaero.com
Sent: April 18, 2011 11:36 AM
To: Linda Lacelle; Mike Petsche
Cc: Bill Beckett; 'Chris Provencal'; 'Eric Charbonneau'
Subject: Re: Alum. Solution Anneal - swaging

Makes sense to me ... We don't want to get caught short ... Make sure that if we do this, they are ident. the old CHG number.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Linda Lacelle" <llacelle@dartaero.com>
Date: Mon. 18 Apr 2011 11:21:10 -0400
To: 'Mike Petsche' <mpetsche@dartaero.com>; <dshepherd@dartaero.com>
Cc: 'Bill Beckett' <bbeckett@dartaero.com>; 'Chris Provencal' <cprovencal@dartaero.com>; 'Eric Charbonneau' <echarbonneau@dartaero.com>
Subject: RE: Alum. Solution Anneal - swaging

I am ready to weld some up, I don't want to get into trouble with L/T's on these, any objections??
LL

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: April 18, 2011 10:42 AM
To: 'Linda Lacelle'; dshepherd@dartaero.com
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Eric Charbonneau'
Subject: RE: Alum. Solution Anneal - swaging

Well I'm not sure what to say.

It is my understanding that the swaging will still make sense even with the extra hoops we need to jump through if there is still uncertainty on the delivery of the material, we CAN still weld them if we need to.

And while this might be less than "world class", couldn't we take some of our tubing that we have in stock and with the welder to knock down the temper a little? Ground clamp on one end, torch on the other.....BZZZZZZZ

(I'm only sort of joking....because I bet it would work)

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April 18, 2011 9:44 AM
To: dshepherd@dartaero.com; 'Mike Petsche'
Cc: Bill Beckett; Chris Provencal; Eric Charbonneau
Subject: RE: Alum. Solution Anneal - swaging
Importance: High

NO. 258

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B69986
Part number: 2205-634-041
Description: 205
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Art Evers Date of Test Coupon 11.06.24
Welder Barclay Elliot Date of Test Coupon 11/06/24

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Dart Aerospace Ltd

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